

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 32778		
Estimate Number	: 11055		
P.O. Number	: N/A	Part Number	: D2884
This Issue	: 6/6/2007	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D2884 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29453	Drawing Revision	: B
		Material	: N/A
Written By	:	Due Date	: 6/20/2007
Checked & Approved By	:	Qty:	40 Um: Each
Comment	:		

Est A 99.10.12 New Issue EC  
Est Rev:B Now 6061-T6 06-06-23 JLM  
Est Rev:C Now on Waterjet 06-08-23 JLM

Job Number:



1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0663 sf(s)/Unit Total: 2.6502 sf(s)  
Material: 6061-T6 0.080" Thick  
Batch M104392

ml 07 06 10

40

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2884  
Dwg Rev: B  
Prog Rev: B

ml 07 06 10

40

2-Tumble, Deburr if necessary      500    07/10/23    40 counted

30 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 06 10



40

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8 SECOND CHECK



SECOND CHECK

2006.12 40



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

MSD

07-06-27

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/06/29

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:48:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 32778

Part Number: D2884

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*EP 07/06/29 (40)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 07/06/29 (40)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(40)*

Comment: FINAL INSPECTION/W/O RELEASE

*EP 07/06/29*

Job Completion



*U 07-06-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

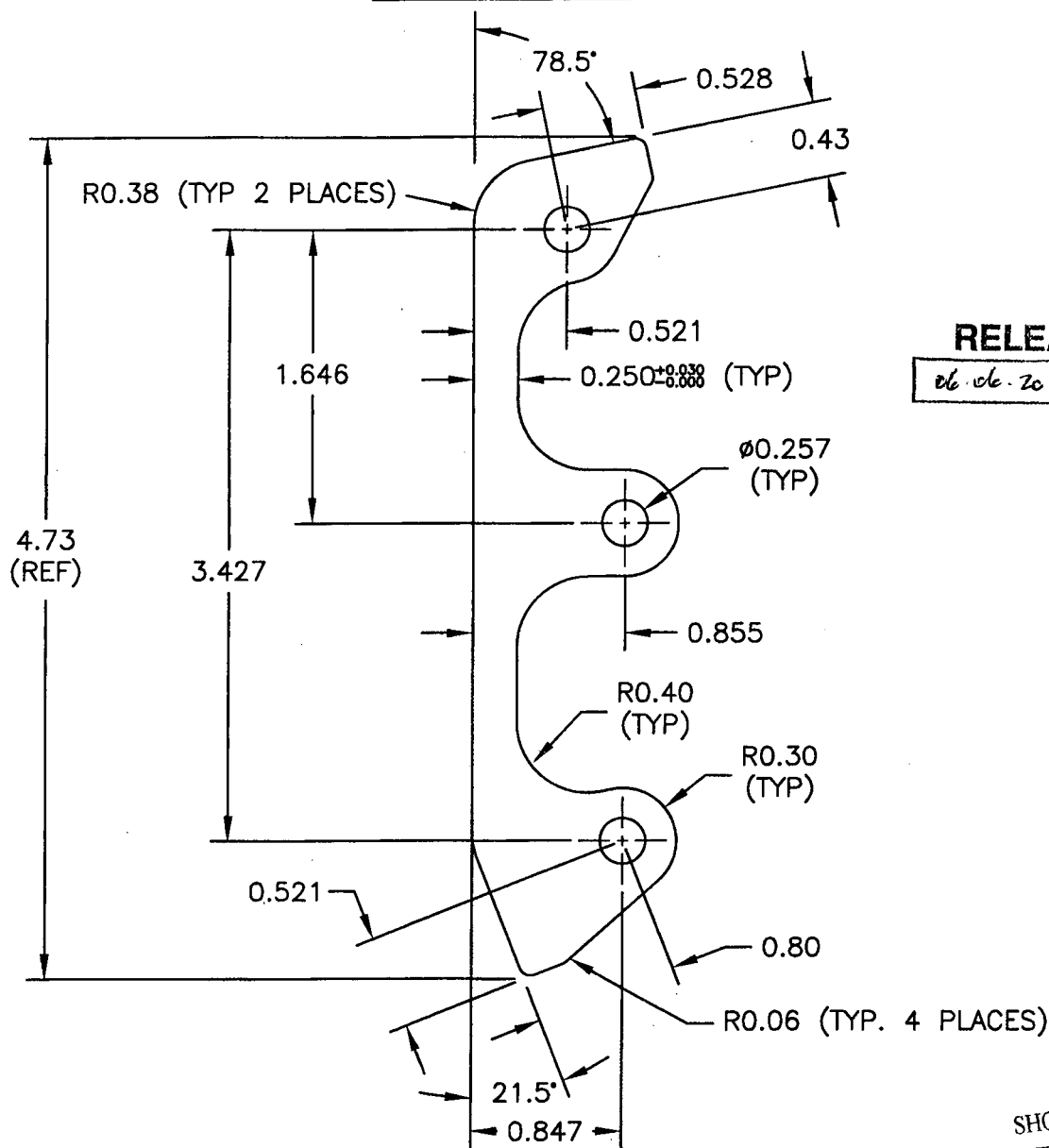
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2884	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	



RELEASED

*ok ok to [Signature]*

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 32778

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